

# Work Order ID 94395

**\*94395\***

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December-12-12 12:55:15 PM

Item ID: D3537-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Wearpad  
 Start Date: 12/12/12 Start Qty: 100.00 **\*100\*** Cust Item ID:  
 Required Date: 12/21/12 Req'd Qty: 100.00 **\*100\*** Customer:  
 Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3537    | Rev C        |

|                   |  |      |  |  |  |     |   |  |          |
|-------------------|--|------|--|--|--|-----|---|--|----------|
| 100               | FLOW WATER JET   | 0.00 |  |  |  | 108 | 0 |  | 12-12-12 |
| <b>*100*</b>      |  |      |  |  |  |     |   |  |          |
| Waterjet          | Memo   | 0.00 |  |  |  |     |   |  |          |
| FLOW CNC Waterjet | 1-Cut as per Dwg D3537Dwg Rev: <u>C</u> Prog Rev: <u>C</u> 2-Deburr if necessary |      |  |  |  |     |   |  |          |

|                 |   |      |  |  |  |     |   |  |          |
|-----------------|---|------|--|--|--|-----|---|--|----------|
| 110             | QC2- Inspect parts off machine FAI/FAIB | 0.00 |  |  |  | 108 | 0 |  | 12-12-12 |
| <b>*110*</b>    |   |      |  |  |  |     |   |  |          |
| QC              | Memo                                    | 0.00 |  |  |  |     |   |  |          |
| Quality Control |   |      |  |  |  |     |   |  |          |

|                 |                                   |      |  |  |  |     |  |  |  |
|-----------------|-----------------------------------|------|--|--|--|-----|--|--|--|
| 120             | QC8- Inspect parts - second check | 0.00 |  |  |  | 108 |  |  |  |
| <b>*120*</b>    |                                   |      |  |  |  |     |  |  |  |
| QC              | Memo                              | 0.00 |  |  |  |     |  |  |  |
| Quality Control |                                   |      |  |  |  |     |  |  |  |

12-12-14

108  
Count

# Work Order ID 94395

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December-12-12 12:55:15 PM

Item ID: D3537-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Wearpad  
 Start Date: 12/12/12 Start Qty: 100.00 **\*100\*** Cust Item ID:  
 Required Date: 12/21/12 Req'd Qty: 100.00 **\*100\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description   | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130                            |  | 0.00                 |         |        |              |               |               |                  |                |
| <b>*130*</b>                   | NC BRAKE   |                      |         |        |              | 108           |               |                  | Sh 12/12/12    |
| Brake NC                       | Memo   | 0.00                 |         |        |              |               |               |                  |                |
| Brake NC                       | 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.2-Identify as D3537-1  |                      |         |        |              |               |               |                  |                |
| 140                            |  | 0.00                 |         |        |              |               |               |                  |                |
| <b>*140*</b>                   | Large Fab  |                      |         |        |              | 108           |               |                  | 13-01-10       |
| Large Fab                      | Memo   | 0.00                 |         |        |              |               |               |                  | JBL            |
| Large Fab                      | Qty Description Batch A/R 2059B Hardcoat<br>M123985/M12385 1-Weld as per Dwg D3537 using Jig DT 82102-Remove any weld that penetrated through Wearpad if necessary |                      |         |        |              |               |               |                  |                |
| 150                            | QC10- Inspect visual per QSI004- ground welds  | 0.00                 |         |        |              |               |               |                  |                |
| <b>*150*</b>                   |  |                      |         |        |              | 108           |               |                  |                |
| QC                             | Memo   | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |  |                      |         |        |              |               |               |                  |                |

DAS  
24  
8-89

13-1-10

# Work Order ID 94395

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Item ID: D3537-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Wearpad  
 Start Date: 12/12/12 Start Qty: 100.00 **\*100\*** Cust Item ID:  
 Required Date: 12/21/12 Req'd Qty: 100.00 **\*100\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID                      | Operation<br>Description  | Set Up/<br>Run Hours | Tool ID | Tool #                                 | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number  | Insp.<br>Stamp |
|---|---|----------------------|---------|--|--------------|---------------|---------------|-------------------|----------------|
| 160<br><b>*160*</b><br>QC<br>Quality Control        | QC5- Inspect part completeness to step on W/O<br><br>Memo   | 0.00<br><br>0.00     |         |  |              |               |               |                   |                |
|   |   |                      |         | <b>DAS</b><br><b>24</b><br><b>8-89</b> |              | <u>108</u>    |               |                   |                |
|   |   |                      |         | <u>13-1-10</u>                         |              |               |               |                   |                |
| 170<br><b>*170*</b><br>Powdercoat<br>Powder Coating | Grey Sandtex (Ref 4.3.5.6) per QSI005 4.3<br><u>M125466</u><br>Memo<br>START TIME: <u>8:20</u> FINISH TIME: <u>3:10</u> OVEN TEMPERATURE: <u>3-40</u> | 0.00<br><br>0.00     |         |  |              |               |               |                   |                |
|   |   |                      |         |  |              | <u>108</u>    | <u>φ</u>      | <u>13-1-15</u>    |                |
| 180<br><b>*180*</b><br>QC<br>Quality Control        | QC3- Inspect Part Finish<br><br>Memo  | 0.00<br><br>0.00     |         |  |              |               |               |                   |                |
|   |   |                      |         |  |              | <u>108</u>    | <u>φ</u>      | <u>M 13/05/16</u> |                |

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Item ID: D3537-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Wearpad

Start Date: 12/12/12 Start Qty: 100.00

\*100\*

Cust Item ID:

Required Date: 12/21/12 Req'd Qty: 100.00

\*100\*

Customer:

Reference:

Run Start \*NR1\*

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

| Sequence ID/<br>Work Center ID | Operation<br>Description                            | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 190                            | Identify as per dwg & Stock Location: <i>FP-001</i> | 0.00                 |         |        |              |               |               |                  |                |
| <b>*190*</b>                   |   |                      |         |        |              |               |               |                  |                |
| Packaging                      | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Packaging                      |   |                      |         |        |              |               |               |                  |                |
| 200                            | QC21- Final Inspection - Work Order Release         | 0.00                 |         |        |              |               |               |                  |                |
| <b>*200*</b>                   |   |                      |         |        |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |

108  $\phi$  12/13-1-15.

13/1/16 *[Signature]*

13-01-16

# Picklist Print

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Page 1

Work Order ID: 94395

Parent Item: D3537-1

Parent Item Name: Wearpad

Start Date: 12/12/12

Required Date: 12/21/12

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M304S16GA

Purchased

No

100

sf

161.3280

0.106

11157895

304/316 Sheet .063

1112

Jm12-12-12

Location

Loc Qty

Loc Code

MAT020

161.328

122245

6.578

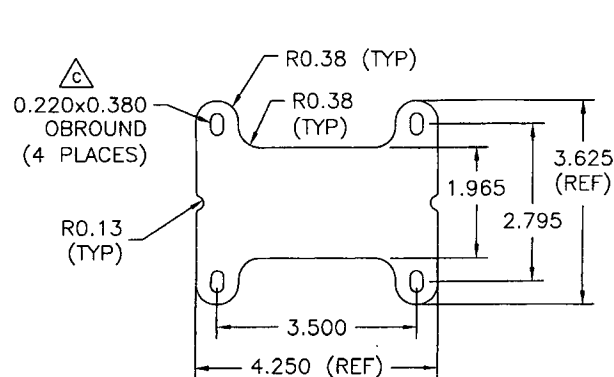
123136

154.75

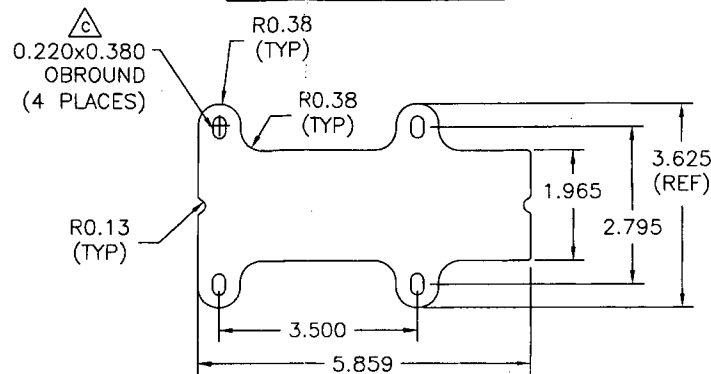
123136

94395

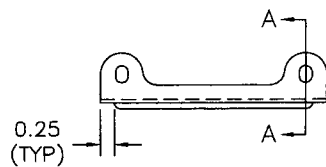
### D3537-1F FLAT PATTERN



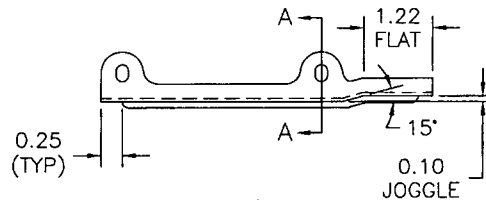
### D3537-3F FLAT PATTERN



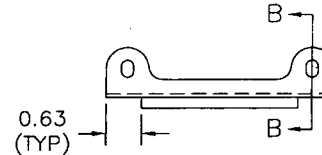
### D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



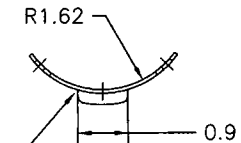
### D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)

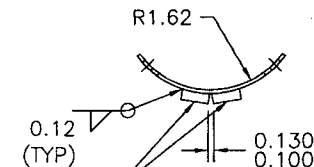


### SECTION A-A



APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

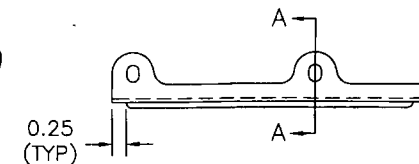
### SECTION B-B



D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

**RELEASED**  
07.05.08  
per EGN  
962

### D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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|              |          |                                  |
|--------------|----------|----------------------------------|
| C            | 07.04.13 | WIDEN TAB TO 0.380, WELD PATTERN |
| B            | 07.03.20 | ADD AMS 5513 AND AMS 5524        |
| A            | 06.11.06 | NEW ISSUE                        |
| DESIGN       | CB       | DRAWN BY PH                      |
| CHECKED      | #        | APPROVED #                       |
| DATE         | 07.04.13 | TITLE WEARPAD                    |
| DRAWING NO.  | D3537    | REV. C                           |
| SHEET 1 OF 1 |          | SCALE 1:2                        |

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